






Work Order ID 51157



August 4, 2009 3:46:17 PM






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Item ID: D3686-041 Accept  Setup Start 
 Revision ID: C Stop 
 Item Name: MONOPOD ASSEMBLY
 Start Date: 08/17/2009 Start Qty: 5.00  Cust Item ID:
 Required Date: 08/17/2009 Req'd Qty: 5.00  Customer:

Reference:

Approvals: Process Plan: WF Date: 09-08-04 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3686	Rev C								
100	Pick Kit	0.00							
	Packaging	0.00							
	Packaging								
110	Small Fab	0.00							
	Small Fab	0.00							
	Small Fab								
	Memo								
	1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686□2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686□***Ensure holes for AN3C B								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Quality Control								

9/8/12 50 Sp

50
SB 09/08/12

2) 8 09/08/12

45 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3686-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	MONOPOD ASSEMBLY					
Start Date:	08/17/2009	Start Qty:	5.00		Cust Item ID:	
Required Date:	08/17/2009	Req'd Qty:	5.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>139E</i>	0.00							
Packaging	Memo	0.00				<i>X5</i>		<i>mp</i>	<i>09/08/12</i>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

0506-13
mk- 09-08-13 *D*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51157

Parent Item: D3686-041RevC

Parent Item Name: MONOPOD ASSEMBLY


Comments:

Start Date: 08/17/2009

Required Date: 08/17/2009


Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C10A  Bolt		Purchased	No			110	Each	66.0000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	66	
102116	7	
105940	59	

MF 09-08-07

AN3C12A  Bolts		Purchased	No			110	Each	635.0000	10.0000			
--	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	635	
106993	7	
110155	2	
110552	4	
110584	72	
111916	50	
112314	500	

MF 09-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 51157



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/17/2009

Required Date: 08/17/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3688-7RevB		Manufactured	No			110	Each	18.0000	5.0000			
STUD												

614605

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

18

44686

1

46055

12

46699

5

MF 09-08-07

D3689-1RevB

Manufactured

No

110

Each

19.0000

5.0000



SLEEVE

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

19

46051

19

50388 MF 09-08-07

D3691-1RevU/R

Manufactured

No

110

Each

17.0000

5.0000



STUD

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

17

46052

17

50721

5

50 09/08/12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/17/2009

Required Date: 08/17/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB SPACER		Manufactured	No			110	Each	106.0000	20.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

106

B 50325

10 5009/08/12

44827

68

45672

38

D3692-3RevB

Manufactured No



SPACER

110

Each

97.0000

20.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

97

44690

97

MP 09-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3686-041RevC

Parent Item Name: MONOPOD ASSEMBLY


Comments:

Start Date: 08/17/2009

Required Date: 08/17/2009


Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3693-1RevU/R		Manufactured	No			110	Each	33.0000	5.0000			
												
Rod End Bearing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
45723	5	
Main Warehouse		
ST127	28	
50734	28	

B50734 MF 09-08-07

D3693-3RevU/R		Manufactured	No			110	Each	8.0000	5.0000			
												
Rod End Bearing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
45724	8	

MF 09-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 51157



Parent Item: D3686-041RevC



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/17/2009

Required Date: 08/17/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			110	Each	5,590.000	20.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	5510	
111819	210	
112243	300	
112314	5000	

MF 09-08-07

NAS509L12C



Purchased

No

110

Each

135.0000

5.0000



Nuts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	135	
106993	5	
110844	30	
112314	100	

MF 09-08-07

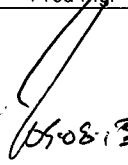
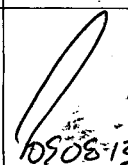
PTD

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
09-08-10	110	Add Qty 1 NASS09-12C Nut M 110844 Penn chg	SB	09/08/11	5		
			CB	09-08-10			

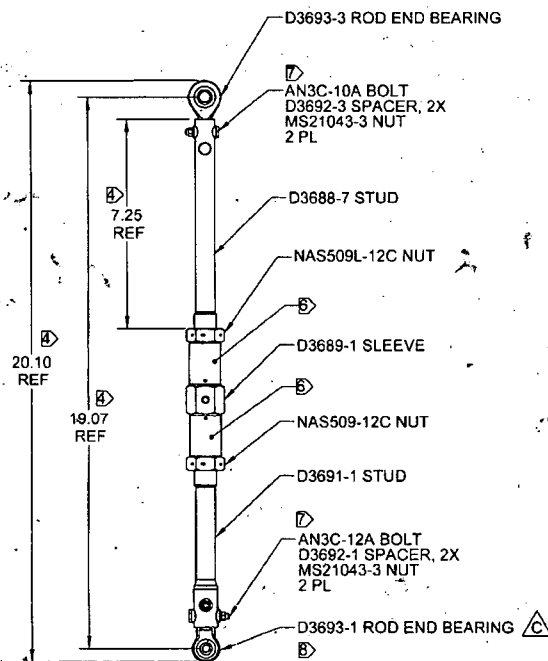
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

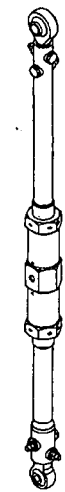
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



#51157
mf
09-08-04



D3686-041 MONOPOD ASSEMBLY

RELEASED
09/01/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3686	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MONOPOD ASSEMBLY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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